

Work Order ID 62151

Friday, September 17, 2010 1:39:45 PM

Page 1

Item ID: D2573

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Aft Out 205

Start Date: 9/17/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2573	Rev E								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No 62151 Double check by: ☐ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3 per Folio FA051 and insp

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Work Order ID 62151

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Item ID: D2573

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Aft Out 205

Start Date: 9/17/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		J.A 10/11/01		12	Ø		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		⇒ J 10/11/01		12	Ø		
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum m 115291 Memo START TIME: 3:40 . OVEN TEMPERATURE: 320° FINISH TIME: 7:10	0.00 0.00				12		10-11-1	

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Item ID: D2573

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Aft Out 205

Start Date: 9/17/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 434

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Handwritten signature 10/11/02 (12)

Handwritten signature 10/11/02 *MF* 10-11-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 62151



Parent Item: D2573



Parent Item Name: Saddle, Aft Out 205


Start Date: 9/17/2010

Required Date: 9/17/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007  Saddle Billet		Manufactured	No			100	Each	26.0000	1	12		10/11/09	

Location

Loc Qty

Loc Code

MAT42

26

46412

2

60314

24

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42151
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.443	.443	.443	.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.003	8.003	8.003		
F	0.490	0.510		.504	.500	.502	.508		
G	0.257	0.262		.255	.258	.255	.258		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.503	.501	.501	.501		
J	1.174	1.184		1.175	1.179	1.179	1.179		
K	0.558	0.578		.568	.567	.566	.567		
L	1.174	1.184		1.175	1.178	1.179	1.175		
M	1.365	1.375		1.369	1.370	1.369	1.370		
N	2.495	2.505		2.495	2.500	2.497	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.126	.126	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.249	.249		
S	0.115	0.135		.137	.127	.126	.126		
T	0.178	0.198		.188	.158	.158	.188		
U	3.210	3.250		3.230	3.230	3.229	3.230		
V	0.230	0.250		.242	.243	.243	.242		
W	0.115	0.135		.122	.129	.126	.126		
X	0.308	0.313		.309	.310	.309	.309		
Y	0.760	0.765		.761	.761	.760	.761		
Z	0.352	0.372		.365	.365	.365	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.629	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.260	.255	.255	.255		
AE	1.500	1.520		1.511	1.511	1.511	1.510		
AF	0.115	0.135		.125	.125	.122	.122		
AG	0.240	0.280		.260	.240	.250	.250		
AH	0.240	0.260		.250	.250	.248	.248		
AI	2.000	2.020		2.001	2.002	2.000	2.001		
AJ	0.023	0.043		.030	.030	.030	.030		
Accept/Reject									

Measured by: SA
Date: 10/10/25

Audited by: H.A
Date: 10/11/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 62151
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5d	6f	7g	8h		
A	0.438	0.443		.443	.443	.443	.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.004	8.004		
F	0.490	0.510		.496	.497	.496	.502		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.502	.502	.502	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.570	.570	.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.127	4.127	4.124	4.124		
P	0.115	0.135		.125	.125	.128	.126		
Q	0.115	0.135		.135	.135	.135	.133		
R	0.240	0.260		.247	.247	.250	.250		
S	0.115	0.135		.127	.127	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.242	.242	.239	.241		
W	0.115	0.135		.130	.130	.125	.129		
X	0.308	0.313		.311	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.627	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.255	.255	.256	.256		
AE	1.500	1.520		1.512	1.512	1.513	1.505		
AF	0.115	0.135		.135	.135	.135	.130		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.247	.247	.245	.245		
AI	2.000	2.020		2.000	2.001	2.000	2.000		
AJ	0.023	0.043		.030	.030	.030	.030		
Accept/Reject									

Measured by: SA
Date: 01/10/28

Audited by: B.A
Date: 10/11/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 02151
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9 1/2	10 1/2	11 1/2	12 1/2		
A	0.438	0.443		.443	.443	.443	.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		.497	.498	.496	.498		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.375	.378	.378	.378		
I	0.490	0.510		.502	.502	.502	.502		
J	1.174	1.184		1.177	1.179	1.177	1.179		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.495	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.245	.249	.245	.245		
S	0.115	0.135		.127	.127	.127	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.242	.242	.242	.241		
W	0.115	0.135		.130	.130	.125	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.255	.255	.255	.255		
AE	1.500	1.520		1.512	1.513	1.513	1.513		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.247	.247	.247	.247		
AI	2.000	2.020		2.000	2.000	2.002	2.002		
AJ	0.023	0.043		.030	.030	.030	.030		
Accept/Reject									

Measured by:	SJ
Date:	10/10/28

Audited by:	B.A
Date:	10/11/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
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